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Page 1

Thursday, August 07, 2014 11:15:21 AM Accept Item ID: D3391-023 *N900040100* Setup Start **Revision ID:** Stop Mid Tube Assembly **Item Name: Start Oty: 1.00** *1* 7/29/14 **Start Date: Cust Item ID:** Req'd Qty: 1.00 Required Date: 8/07/14 **Customer:** Reference: Run Start Date: 14-08-08 Process Plan: MUJ Approvals: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Reject Sequence ID/ Set Up/ Operation Tool ID Tool # Plan Accept : Reject Insp. Number **Work Center ID Description** Code Qty **Qty** Stamp **Run Hours Draw Nbr Revision Nbr** D3391 Ι 100 0.00 Skidtubes *100* 0.00 Skidtubes Memo Skidtubes 1-Cut tube to finish length as per Dwg D3391 2-Drill pilot holes using DT8796 (Do not drill "B" holes) and drill only 1 fwd saddle hole on one side only as per Dwg D3391 3-Open saddles and GHW holes to Ø0.375" exept for fwd saddle hole of detail 4-Remove .030" from Fwd indexing Ridge as per Dwg D3391 5-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391 6-Deburr 7-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with ***DO NOT DRILL HOLES #3-19-20 FROM FWD END OF JIG 8-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (10 holes) as per Dwg D3391 9-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.297" (20 holes) as per Dwg D3391 ***DO NOT OPEN 2 MOST FWD WEARPLATE HOLES***

DQA:			Date:			<u></u>				_			•	DART
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		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong		
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Thursday, Aug	ust 07, 2014	11:15:22 AM			14/A"					
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Item Name:	Mid Tube As	ssembly								Si
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Required Date	e: 8/07/14	Req'd Qty: 1.00	*1*		Customer:					
Reference:			•			d.				_
Revision ID: Item Name: Mid Tube Assembly Start Date: 7/29/14 Start Qty: 1.00 *1* Cust Item ID Required Date: 8/07/14 Req'd Qty: 1.00 *1* Customer: Reference: Approvals: Process Plan: Date: Tooling: Date	ate:	- 	F	Run	Sta					
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	ID	_		-	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty	
		11-Locate I 12- Transfe remaining f dia hole, us tranfer drille D3391-021 13- Using I wearplate h 14- Locatin wearplte ho	or drill one fwd saddle hole wd saddle holes using DT ing t-pins and clicos to ensed pilot holes in D3391-02 BATCH: #15 50/ DT8217, locating from two oles into D3391-021. g from two fwd wearplate les in D3391-021 using D	at 9.00" (see view z-z) e only to .188" dia, transfe 8149 locating from previ sure perfect allingment, op 23/-021 to 0.438" dia. in I opreviusly drilled holes, d holes in D3391-023 drill T8937	er drill all iusly drill .188" pen up previusly D3391-021 drill remaining	\.				
		1	•	1-021 to 0.297" dia.			17/		14	P_

17- insert T-pins into first and third fwd saddle holes

at aft end.

18- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500"

20-Deburr and blow out all chips from inside tube, scribe batch # in D3391-923

19- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499".

14-8-14

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Part N	o.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
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Work Order ID 123428

Quality Control

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Thursday, August 07, 2014 11:15:22 AM Accept *N900040100* Item ID: D3391-023 Setup Start **Revision ID:** Stop **Item Name:** Mid Tube Assembly *1* 7/29/14 **Start Qty:** 1.00 **Start Date: Cust Item ID:** Required Date: 8/07/14 **Req'd Qty:** 1.00 *1* **Customer:** Reference: Run Process Plan: _____ Tooling: Date: Date: **Approvals:** Stop Date: _____ SPC (Y/N): Date: QC: Reject Reject Set Up/ **Tool ID** Tool # Plan Insp. Sequence ID/ Operation Accept Qty Stamp Qty Number Work Center ID Code **Description Run Hours** QC5- Inspect part completeness to step on W/O 0.00 110 DAS 140818 *110* 9 0.00 Memo 9-89 Quality Control Chemical Conversion Coat per QSI005 4.1 0.00 120 *120* 0.00 HandFinish Memo Hand Finishing 0.00 QC7-Inspect Chemical Conversion Coat 130 D 14-8-20

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Thursday, August 07, 2014 11:15:22 AM

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Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):	Date		Run	Start Stop	^1ZI+	२1* २2*
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		Wave/Tw	vist in Tub	e		Fit/Function		Out of	Sequence				

Work Order ID 123428

Quality Control

Thursday, August 07, 2014 11:15:22 AM

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Item ID: D3391-023 Accept *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Mid Tube Assembly *1* **Start Date:** 7/29/14 **Start Qty:** 1.00 **Cust Item ID:** Required Date: 8/07/14 Req'd Qty: 1.00 *1* **Customer:** Reference: Run Process Plan: Date: **Tooling:** Date: **Approvals:** Stop SPC (Y/N): Date: Date: Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Sequence ID/ Code Qty Number Stamp **Work Center ID Description Run Hours** Qty 0.00 160 Skidtubes *160* 0.00 Skidtubes Skidtubes QC10- Inspect visual per QSI004- ground welds 170 DAS 14/0/27 *170* 16 0.00 9-89 QC Memo Quality Control DAS 16 QC5- Inspect part completeness to step on W/O 0.00 180 9-89 *120* QC 0.00 Memo

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	Mid Tube Ass 7/29/14 : 8/07/14 Process Pla QC:	Mid Tube Assembly 7/29/14 Start Qty: 1.00 : 8/07/14 Req'd Qty: 1.00 Process Plan: QC: Operation Description Pressure Wash per QSI00 Memo AND REAL White Gloss(Ref:4.3.5.1) Memo START TIM OVEN TEM FINISH TIM QC3- Inspect Part Finish	Mid Tube Assembly 7/29/14 Start Qty: 1.00 **1* : 8/07/14 Req'd Qty: 1.00 **1* Process Plan: Date: QC: Date: Operation Description Pressure Wash per QSI005 4.3 Memo AND REALODINE AS PER PAR09 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME:	Mid Tube Assembly 7/29/14	Mid Tube Assembly 7/29/14	Mid Tube Assembly 7/29/14	Mid Tube Assembly 7/29/14 Start Qty: 1.00 *1 * * * * * * * * *	Mid Tube Assembly 7/29/14	Mid Tube Assembly 7/29/14	Stop Stop	Stop Stop

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Packaging

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Thursday, August 07, 2014 11:15:22 AM Accept Item ID: D3391-023 *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Mid Tube Assembly *1* Start Qty: 1.00 **Start Date:** 7/29/14 **Cust Item ID: Req'd Qty:** 1.00 Required Date: 8/07/14 *1* **Customer:** Reference: Run Process Plan: ____ Date: **Tooling: Approvals:** Date: Stop QC: Date: Date: SPC (Y/N): Reject Reject Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Insp. Number **Description** Code Oty **Qty** Stamp **Work Center ID Run Hours** 0.00 230 HandFinishing *230* 0.00 HandFinish 1- press fit D3591-1 spacers using DT9416 starting from 0.500" side Hand Finishing 2-Install Inserts as per Dwg DAS QC5- Inspect part completeness to step on W/O 0.00 240 *240* 0.00 Memo Quality Control 0.00 D412-742-043/B115491 Identify as per dwg & Stock Location. 250 1 d Al relogiza *250* Packaging 0.00 Memo

DQA:			Date:											TAAG
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QA Closed:			Date:							V	OIK OIGEI G	date only		
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Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	ヿ	Quality
	•		······································		_	Use-as-is	1		noforming	Finishing	Rec/Sto	e/Packaging		Other
NCR N	lo.					Suspected Unapproved]		Large Fab	Composite		Supplier		
											_			
Root					Desc	ription of work order update		nitial	Acti		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	<u> </u>	QC Inspector
Design			i											
Doc/Data											'			
Equip/Tooling														
Handling/Pre														
Material														
Operator														
Offset/Setup				,										
Process														
Supplier														
Training Transport	_													
Unapproved	_				-									
	L		J	·	1		FA	ULT CA	TEGORY					
Landi	ng (Gear				General						<u> </u>		
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	F	Pressure/Forced
		Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí	1	Temperature/Cure
		Crimp/Kiı	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/Mi	ssing	∟ٰٰ	Weld
		Cuffs				Contamination		Instruct	tions Incomplete/U	nclear	Part Moved	1	\	Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V			
		Heat Trea	at			Cut Too Short		Mislabe	eled	L	Power Loss/	Surge		Other
	L	Inspectio	n Strip in	Tube	<u> </u>	Drawing		Misrea						
		Marks/Ch			<u> </u>	Drill Holes		Off-set						
	L	Turning S	•			Finish		4	Calibration					
1.	Wave/Twist in Tube				Fit/Function		Out of	Sequence						

Work Or Thursday, Aug				*12			Page	
Item ID: Revision ID: Item Name:	D3391-023			Accept	*N900040100*	Setup S	Start Stop	*NS1*
Start Date: Required Dat Reference:	7/29/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:			14.32
Approvals:	Process P. QC:	lan:	Date:	Tooling: SPC (Y/N):	Date: Date:		Start Stop	*NR1* *NR2*

Sequence ID/ **Work Center ID** Operation

Description

Set Up/ Run Hours Tool ID

Tool # Plan Code Accept

Reject

Reject Number Stamp

Insp.

Page 8

260

QC21- Final Inspection - Work Order Release

0.00

260

Quality Control

Memo

0.00

DQA: Date:														
				WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed:			Date:			Work Order update only								
NA/ and a Constant				DISPOSITION										
Work Order:					Rework			Skid-tube Crosstube			Water Jet	Engineering		
Part N	ο.					Scrap		Machining Small Fab			Pro	d. Eng. Coor.	Quality	
rait No.					Use-as-is			Thermoforming Finishing			e/Packaging	Other		
NCR N	lo.					I "			~ <u>~</u>					
Root	1		. 1		Desci	ription of work order update		nitial	Action		Sign &			
Cause	1 - 1 - 1 - 1				or non-conformance		ief Eng	Description			Verification	QC Inspector		
Design				•										
Doc/Data														
Equip/Tooling														
Handling/Pre														
Material							İ				·			
Operator														
Offset/Setup														
Process	:ess													
Supplier	upplier						,							
Training														
Transport					ļ.									
Unapproved				<u> </u>										
•							FA	ULT CAT	TEGORY				<u> </u>	
Landi	_	1			_	General		1			1		¬	
	Bending				Bend	<u> </u>	Folio/Program			Outside Dim	<u> </u>	Pressure/Forced		
		Centre Not Concentric BOM/Route				<u> </u>	Grain			Over/Under tolerance		Set-up		
		Cracks				Broken/Damage/Defect	<u> </u>	1	Hardware		Part Incorrect		Temperature/Cure	
		Crimp/Kir	ık/Ripple	/Wave	<u> </u>	Burrs		Inspection Incomplete/Unqualified		<u> </u>	Part Lost/Missing		Weld	
	Crushing Countersin			<u> </u>	Contamination	\vdash	-	tions Incomplete/Unclear	-	Part Moved	<u> </u>	Wrong Stock Pulled		
				4	<u> </u>	1	gned/off center	-	Positioned V	_	70***			
	Heat Treat Cut Too Short		-	<u> </u>	Mislabeled			Power Loss/	Surge	Other				
		Inspection		Tube		Drawing	\vdash	Misrea						
Marks/Chatter Drill Holes				<u> </u>	Off-set				***************************************					
		Turning S				Finish Fit /Function	\vdash	4	Calibration					
		110/21/0/11/4	OCT IN 1111	143		1 = 11 / E11/1//11/1/1		II HIT OF '	SOMETHIC !!				I I	

Picklist Print

Thursday, August 07, 2014 11:15:20 AM

Work Order ID: 123428

123428

Parent Item:

D3391-023

D3391-023

Parent Item Name:

Mid Tube Assembly

Start Date: 7/29/14

Required Date: 8/07/14

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP A05.10.20New Issue

KJ/EC

IPP B06.02.10ECN773 dwg rev.D EC

IPP C 07.03.20 rev F dwg

EC

IPP D 07.03.28 re-format EC

EC

IPP E 07.10.31 ecn 1053P

IPP Rev:F ECN 1056 07-11-13 DD

verified by: EC

IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC

IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC

IPP Rev: I 08-11-13 Removed steps per w/o, QC KJ verified by: ec

Rev:J add in seq 140 expire date &b# sikaflex DD 10.02.17 verified by:EC

•	teris add in seq 1												
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-100		Manufactured	No			100	Each	67.0000	1 (NA	$\overline{)}$		-
D2500-1-	-100								**		14	8-B	
				Location	!	Loc	<u>Oty</u>	Loc Code					
				HALL			67		1	\sim	_		
				(-	82373 86065		14 53		(2	/	-		
D3389-1		Manufactured	No			140	Each	2.0000	1	1			
*D3389-13	*	·							**				
				Location		Loc	<u>Otv</u>	Loc Code			N .	ac 148	- 7∧
				LG002	1/5652		2 2		_		- <i>O</i>	BC 110	-20
D3681-1		Manufactured	No		11,707	160	Each	65.0000	5	5	_		
*D3681-1	*								**		B	E146	18-21

Spacer

Loc Code Location Loc Qty LG001 65 57 8

DQA: Date:														DART
QA Closed: Date:						WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only								AEROSPACE
Q, (c.osea.						DICROCITION						· · · · · · · · · · · · · · · · · · ·	<u> </u>	
Work Order:			DISPOSITION				AGAINSI D	EPARTMENT, —	PROCESS _	_				
	Ī					Rework		Skid-tube Crosstube			Water Jet			ingineering
Part N	١٥.					Scrap		Machining Small Fab			Prod. Eng. Coor.			Quality
						Use-as-is			noforming	Rec/Stoi	re/Packaging	4	Other	
NCR No.					Suspected Unapproved	<u> </u>	Large Fab Composite			Supplier				
Root					Desc	ription of work order update		nitial	Act	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification		QC Inspector
Design														
Doc/Data	\Box	,								·			1	
Equip/Tooling	Ш		į		Ì									
Handling/Pre												:		
Material														
Operator					i									
Offset/Setup														
Process	\vdash						İ							
Supplier Training	H													
Transport	H											1		
Unapproved														
-	L			·	<u>. </u>		FA	ULT CA	TEGORY		. <u></u>			
Landi	ng (Gear				General								
		Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pre	essure/Forced
		Centre N	ot Concer	ntric		BOM/Route		Grain			Over/Under tolerance		Se	t-up
	Cracks			Broken/Damage/Defect		Hardware			Part Incorrect		Te	mperature/Cure		
Crimp/Kink/Ripple/Wave			Burrs		Inspection Incomplete/Unqualified		nqualified	Part Lost/Missing		\w _{\(}				
Cuffs			Contamination		4	tions Incomplete/U	Jnclear	Part Moved]Wr	rong Stock Pulled			
	Crushing			Countersink		Misaligned/off center			Positioned V		_	_		
Heat Treat			Cut Too Short		Mislab		L	Power Loss/	Surge	Ot	her			
Inspection Strip in Tube			Drawing	<u></u>	Misrea									
	Marks/Chatter			<u> </u>	Drill Holes		Off-set				N-			
		1	Sequence		<u> </u>	Finish		-t	Calibration				-	
1	Wave/Twist in Tube				Fit/Function		Out of	Sequence						

Picklist Print

August-07-14 1:13:24 PM

Page 2

Work Order ID: 123428

123428

D3391-023

Parent Item:

D3391-023

Parent Item Name: Mid Tube Assembly

Start Date: 7/29/14

Required Date: 8/07/14

Start Qty: 1.00

Required Qty: 1.00

D3591-1

. . .

Manufactured

Each

94.0000

2

D3591-1

Bushing

Locatio	<u>on</u>	<u>Lo</u>	c Oty	Loc Code		
FG			10			
	115645		4			
	92873		6			
FP			84			
	115533		58			_x2_
	121446		26			
		230	Each	5,259.000	20	20 .

ALS4-1032-130

AELS4-1032-130 Purchased

No

**

AI S4-1032-130/
Rivnut ALSH-1037-130

Location	Loc Oty
ST267	5259
M126109	57
M128211	48
M128649	5154

Loc Code



